

Date: Thursday, 2/7/2008 11:55:22 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : MAIN PANEL

Job Number : 37293

Estimate Number : 13164

P.O. Number :

This Issue : 2/7/2008

S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : R & D SM/MED FAB

Previous Run :

Written By :  Part Number : D37051Checked & Approved By :  Drawing Number : D3705 U/R

Comment : Est Rev:A 08-01-30 new issue EC verified by:DD Project Number : N/A

Material :

Due Date : 2/14/2008

Qty: 

Um: Each

PROTOTYPE

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet




Comment: Qty.: 2.1651 sf(s)/Unit Total : 2.1651 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch: 106320 LB 8-2-7

CERTIFICATE OF CONFORMITY
REQUIRED
Last Page.

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: U/R

Prog Rev: U/R

LB 8-2-7

2- Deburr if necessary

LB 8-2-7



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



LB 8-2-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

10802.07

5.0

SMALL FAB 1

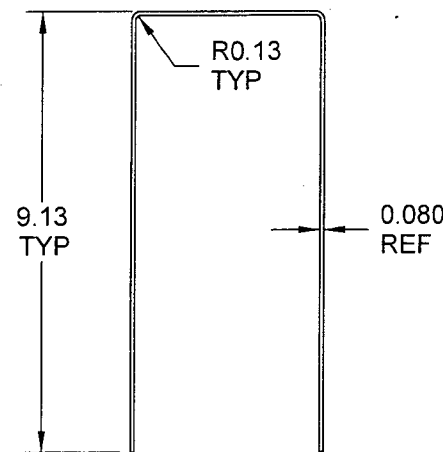
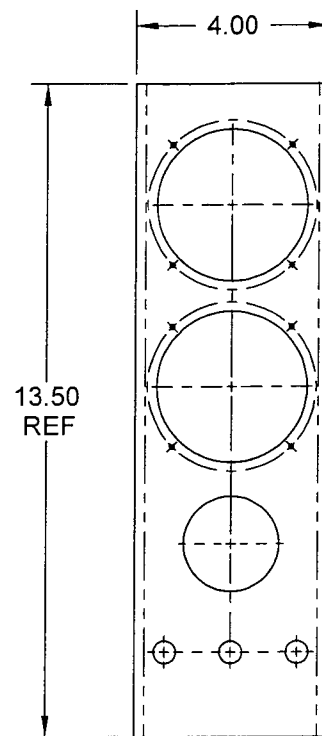
SMALL & MEDIUM FAB RESOURCE 1



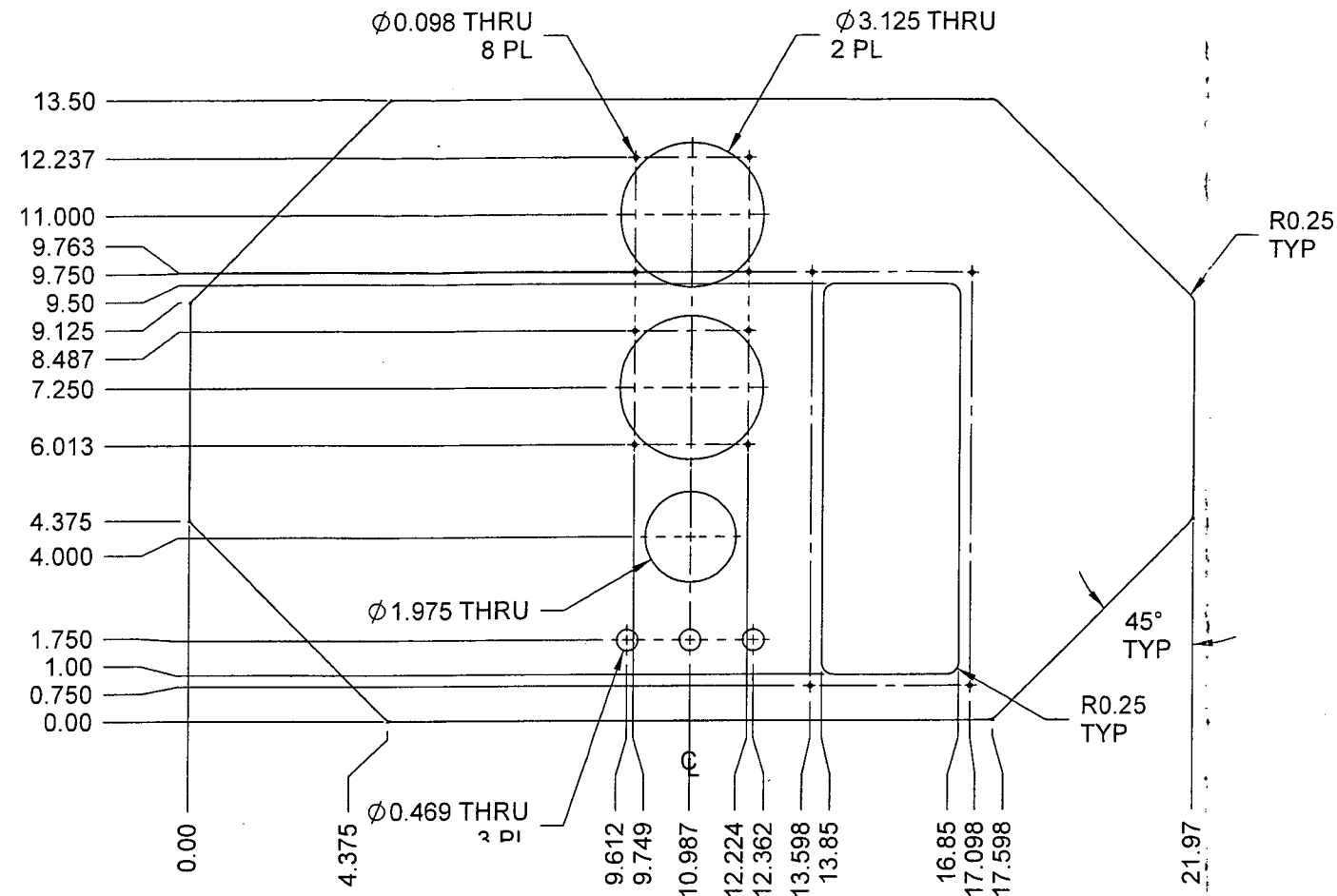
Comment: SMALL & MEDIUM FAB RESOURCE 1

1- BEND AS PER DWG D3705

10802.07



D3705-1 MAIN PANEL
(MAKE FROM D3705-1F)



D3705-1F MAIN PANEL

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
1506-930000
PRELIMINARY ISSUE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3501	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MAIN PANEL	1:4
DATE	08.02.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/08	5-D	ONE D3705-1 SCRAP WAS DEFORMED DURING BENDING R.C. MUMMAN ENRZ	/08/02/08	SCRAP and destroy no replace Qty (X1)	08/02/08	08/02/08	/08/02/08	08/02/08

NOTE: Date & initial all entries

Date: Thursday, 2/7/2008 11:55:22 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MAIN PANEL	PROTOTYPE
Job Number : 37293		
Estimate Number : 13164		
P.O. Number :	Part Number : D37051	
This Issue : 2/7/2008 S.O. No. :	Drawing Number : D3705 U/R	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : U/R	
Previous Run :	Material :	
Written By : <u>EC</u>	Due Date : 2/14/2008	Qty: <u>1</u> Um: Each
Checked & Approved By : <u>EC</u>		
Comment : Est Rev:A 08-01-30 new issue EC verified by:DD		

Additional Product

Job Number:



(PD) →
 last page

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet



Comment: Qty.: 2.1651 sf(s)/Unit Total: 2.1651 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: 106320 IB 8-2-7

CERTIFICATE OF CONFORMITY
 REQUIRED

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: U/RProg Rev: U/RIB 8-2-7

(2)

2- Deburr if necessary

IB 8-2-7

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-2-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

108-02-07

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- BEND AS PER DWG D3705

108-02-07

Receiving Report

Date: 7/11/21

Batch No: M106320

Supplier: MAGNA

Dart P/O: 5024

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☒
 QC6 Inspection 6 Alu 121 N/A ☒
 Work Order N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

07/11/21
RIP 6099
GZ

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total
 G.S.T.

2460.00
 147.60

TOTAL →

2607.60

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
 AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

DOC : V/0000250010

DATE : 2007-09-27

PROD. REF. : 0000271875/002

TEST : 14906/02

PAGE : 1 / 2

INSPECTION CERTIFICATE

Aleris
Europe

CUSTOMER : ALERIS ROLLED PRODUCTS

1700 BAYPOINT PARKWAY, SUITE 200
LOUISVILLE, KY 40223 USA

Aluminum Duffel BVBA
A Division of ZWILLER-Jaeken
Tel: 00352 11-3601000

DESCRIPTION : ALU SHEET (STAINLESS)
DIMENSIONS : 144" X 48" X .06"
ARTICLE NO. :

YOUR ORDER NUMBER : 400165-100 (VANDS FOR 7000000002)
OUR ORDER NUMBER : 14906/02
DOCUMENT NUMBER : V/0000250010

CHEMICAL COMPOSITION (%)

COIL NUMBER	CAST NUMBER	SI	FE	CO	NI	MO	CR	TI	ZN
001	166441	0.10	0.1	0.15	0.15	0.2	0.04	0.16	0.25
		MAX	0.1	0.1	0.15	0.2	0.04	0.16	0.25
		MIN	0.02	0.4	0.20	0.08	1.0	0.16	0.02

OTHERS : EACH : 0.05 MAX
TOTAL : 0.15 MAX

TEST NUMBER	MIN	MAX
001	48	48
001	48	48
001	48	48

1/2 - REEL END
1/2 - TRANSVERSE
1/2 - LONGITUDINAL
1/2 - WIDEL
1/2 - PUNCT END
1/2 - RANDOM SAMPLING

OCT 25 2007

Aleris Aluminum Duffel BVBA

BY *Handwritten Signature*
NIELSEN GARDNER CERTIFICATION PROCESSOR

REGIONAL DISTRICT OF MONTREAL

11/21/2007 WED 8:24 FAX 613 632 4443 DART HELICOPTER SERVICES --- DAS - LINDA

003/003

11/21/2007 WED 8:16 FAX 5146312202 Magna - J Palmer

003/003

Aleris Aluminium Duffel BVBA

DOC : V/0080250860 DATE : 2007-09-27 PROD. REF. : 0000227975/002 INOST : 14906/02 PAGES : 2 / 2

Aleris
Europe

Head of Laboratory:
KATIE SCHMIDT

DATE SOLUTION HELT TREATMENT COIL NUMBER
001 STRENGTHENING : YEAR 35 / YEAR 2007

Aleris Aluminium Duffel BVBA
Avenue 82 100 Duffel - Belgium
Tel 0318 602111 - Fax 0318 602114